




# Work Order ID 54345

December 8, 2009 8:49:51 AM


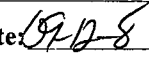




Page 1

Item ID: D3769-5 Accept  Setup Start   
Revision ID: Stop   
Item Name: Tube


Star Date: 08/12/2009 Start Qty: 20.00  Cust Item ID:  
Required Date: 16/12/2009 Req'd Qty: 20.00  Customer:


Reference:


Approvals: Process Plan:  Date:  Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3769	Rev A

100	Small Fab	0.00							
	Small Fab								
Small Fab	Memo	0.00							
	1-cut tube to lenght as per dwg D3769 2-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig 3- deburr								

110	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

120	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							

20X

M-L 10/01/07

27 S 10/01/07

counters  
X20

BR 10-01-7

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54345**

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Page 2

Item ID: D3769-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 03/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/01/07 20

140

Identify as per dwg & Stock Location: 247

0.00



Packaging

Memo

0.00

Packaging

10/01/07 (20)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/07 HJmrf  
10-01-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December 8, 2009 8:49:55 AM

Page 1

Work Order ID: 54345



Parent Item: D3769-5



Parent Item Name: Tube

Start Date: 08/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased	No			100	f	58.3994	35.2463			
6061T6 RD TUBE 1.00 x .065w												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

58.3994082

110778

2.18

111029

56.2194082

M113511

20 X

10/01/06

m.k

\*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

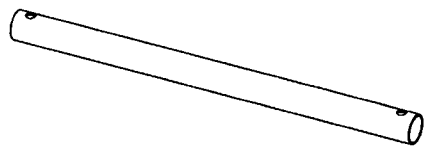
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

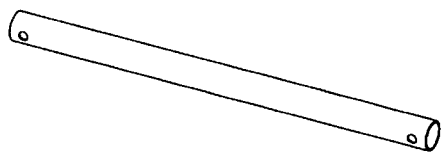
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

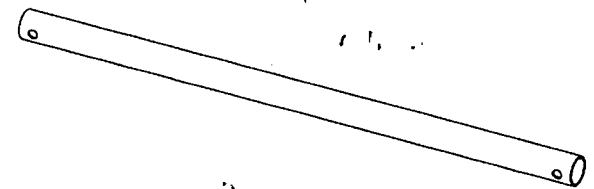
8 7 6 5 4 3 2 1



D3769-1 TUBE



D3769-3 TUBE







D3769-5 TUBE

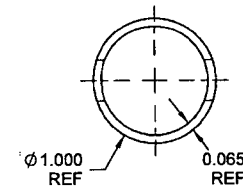
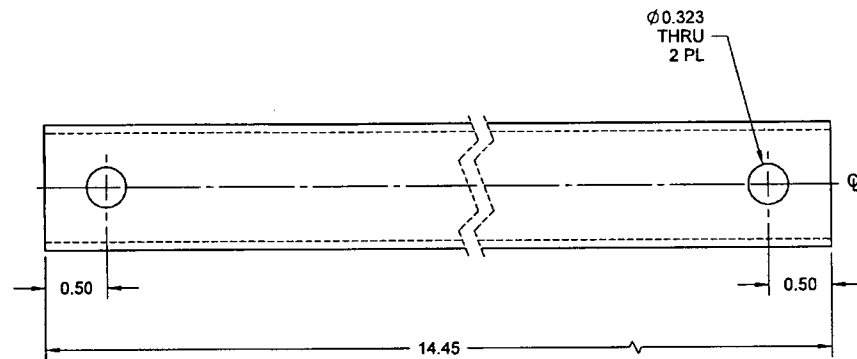
SHOP COPY  
RETURN TO  
ENGINEER  
UNCONTROLLED  
SUBJECT TO APPROVAL  
WITHOUT NOTICE  
WORK ORDER  
NO. 54345  
PL0912-8

RELEASED  
08.06.15.10

- NOTES:  
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: D3769-1, 0.27 lbs  
D3769-3, 0.28 lbs  
D3769-5, 0.37 lbs

A		NEW ISSUE		HS	08.06.04
REV.		DESCRIPTION		BY	DATE
DESIGN		HS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.				D3769	
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DE APPR.				TUBE	
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8 7 6 5 4 3 2 1



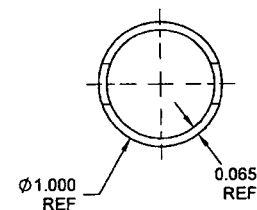
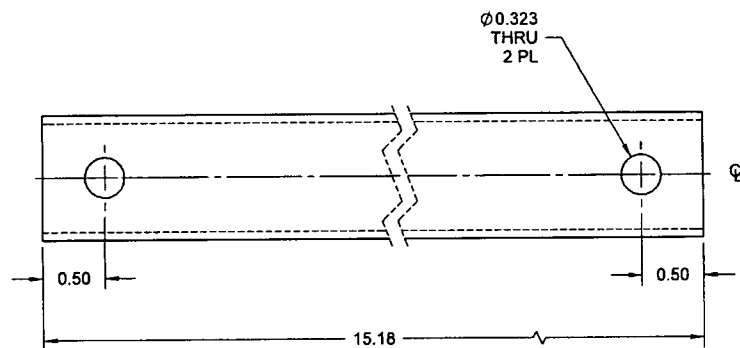
**D3769-1 TUBE**

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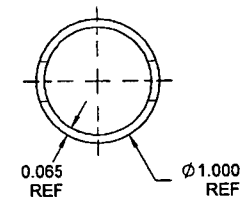
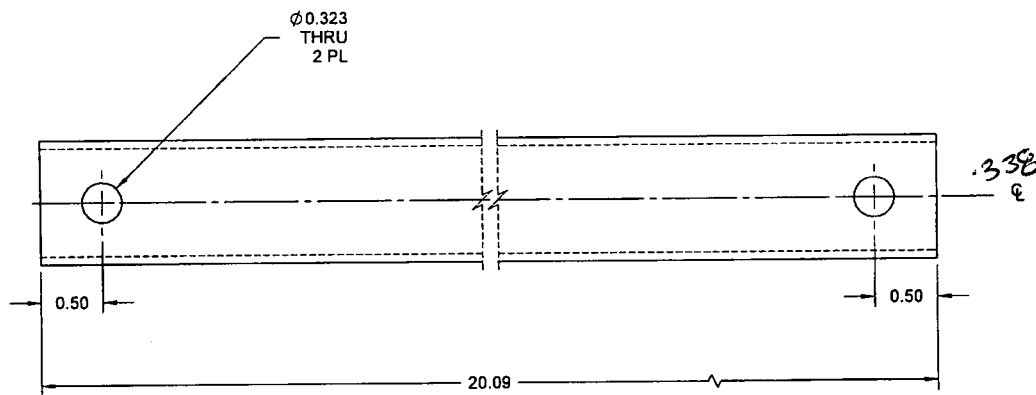


**D3769-3 TUBE**

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W10 54345

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**D3769-5 TUBE**

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